

FIG. 2

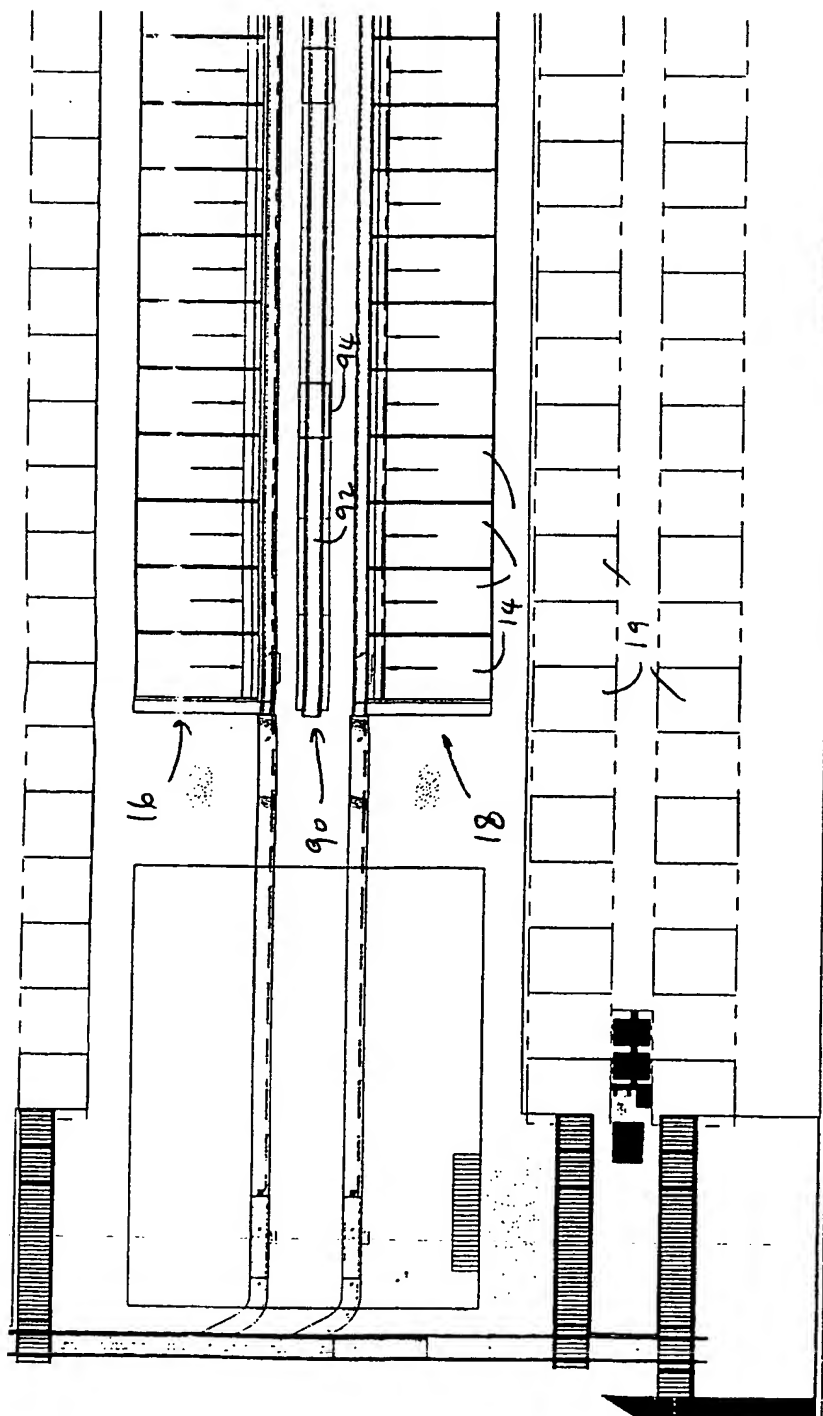


FIG. 3

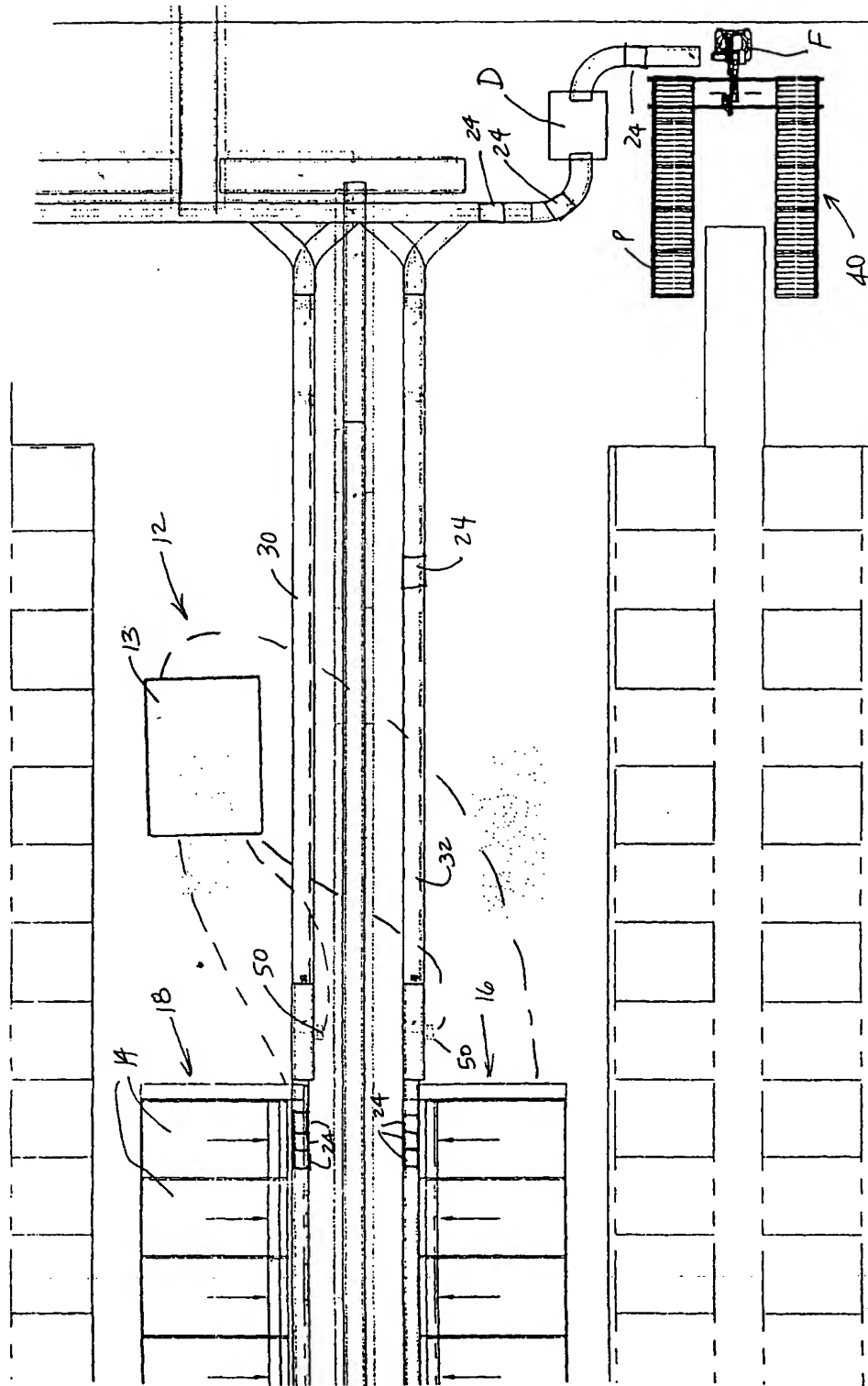


FIG. 4

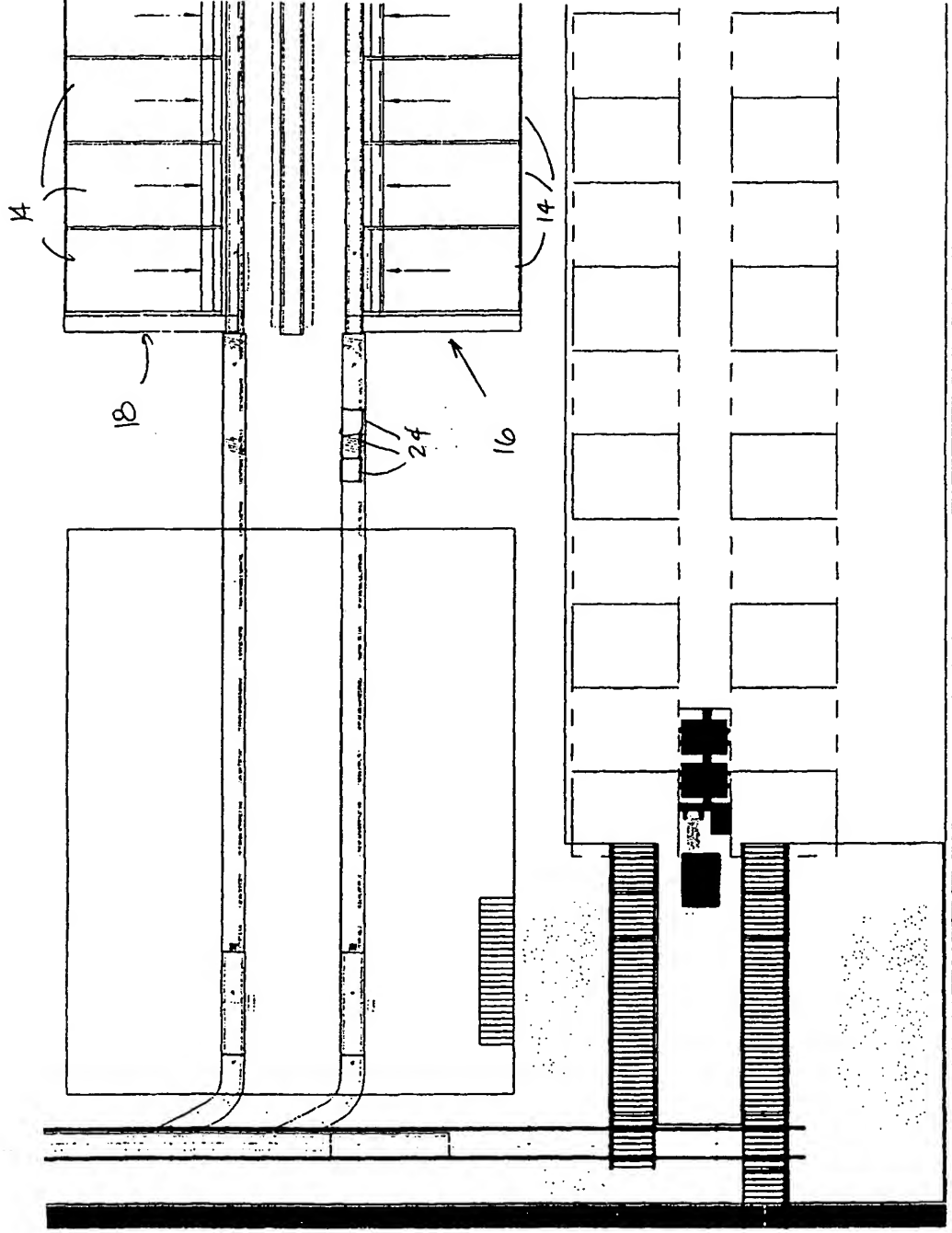


FIG. 5

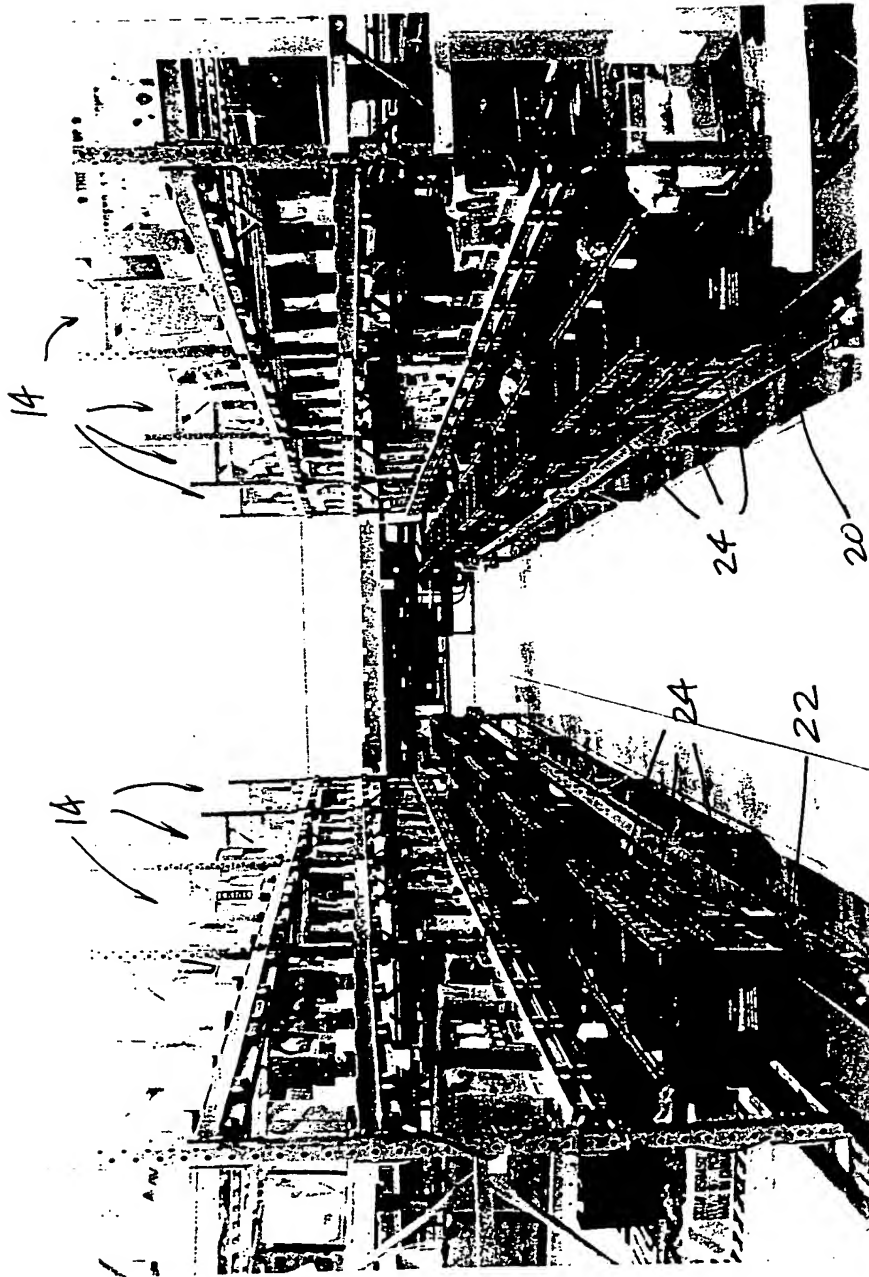


FIG. 6

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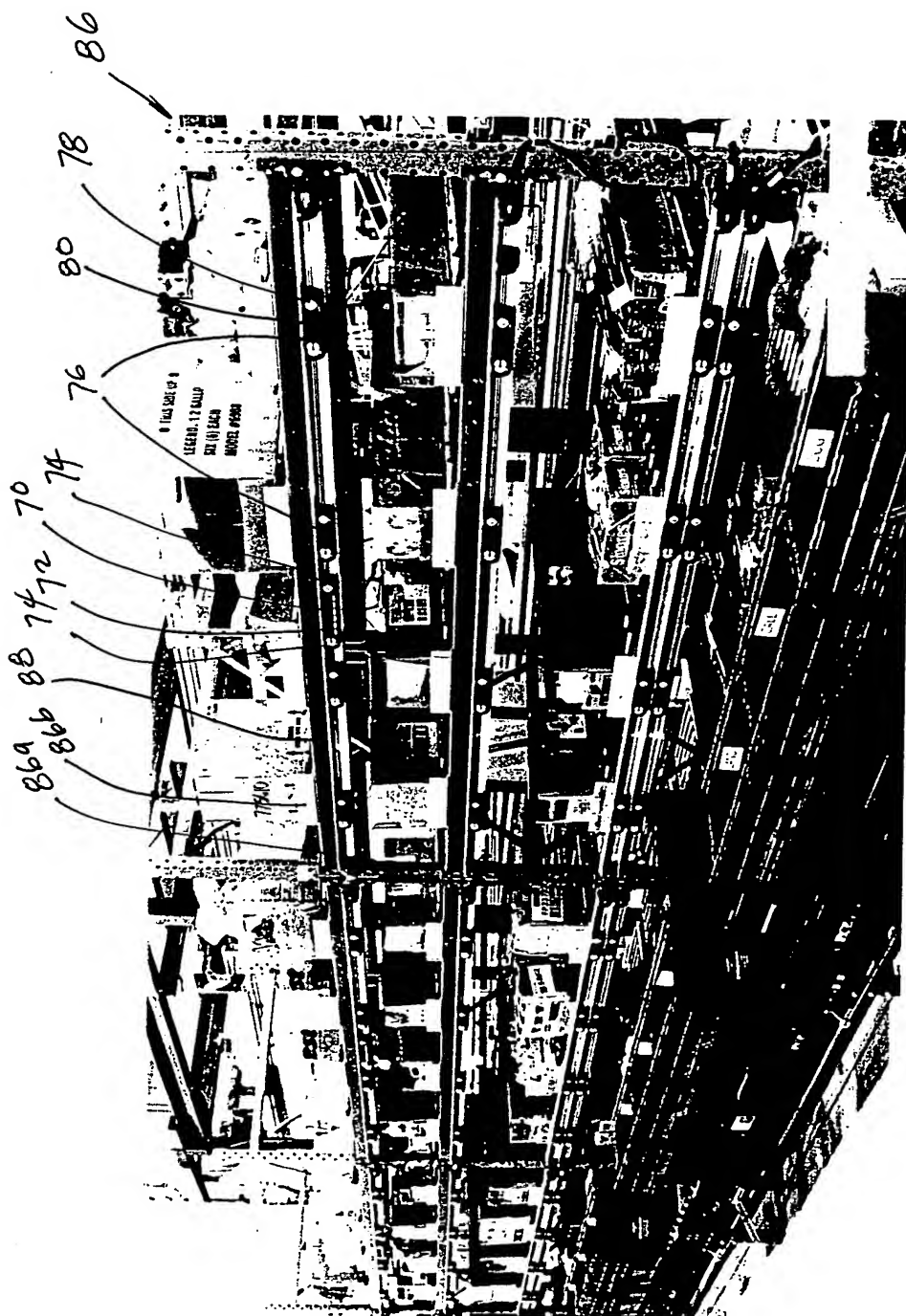


FIG. 7

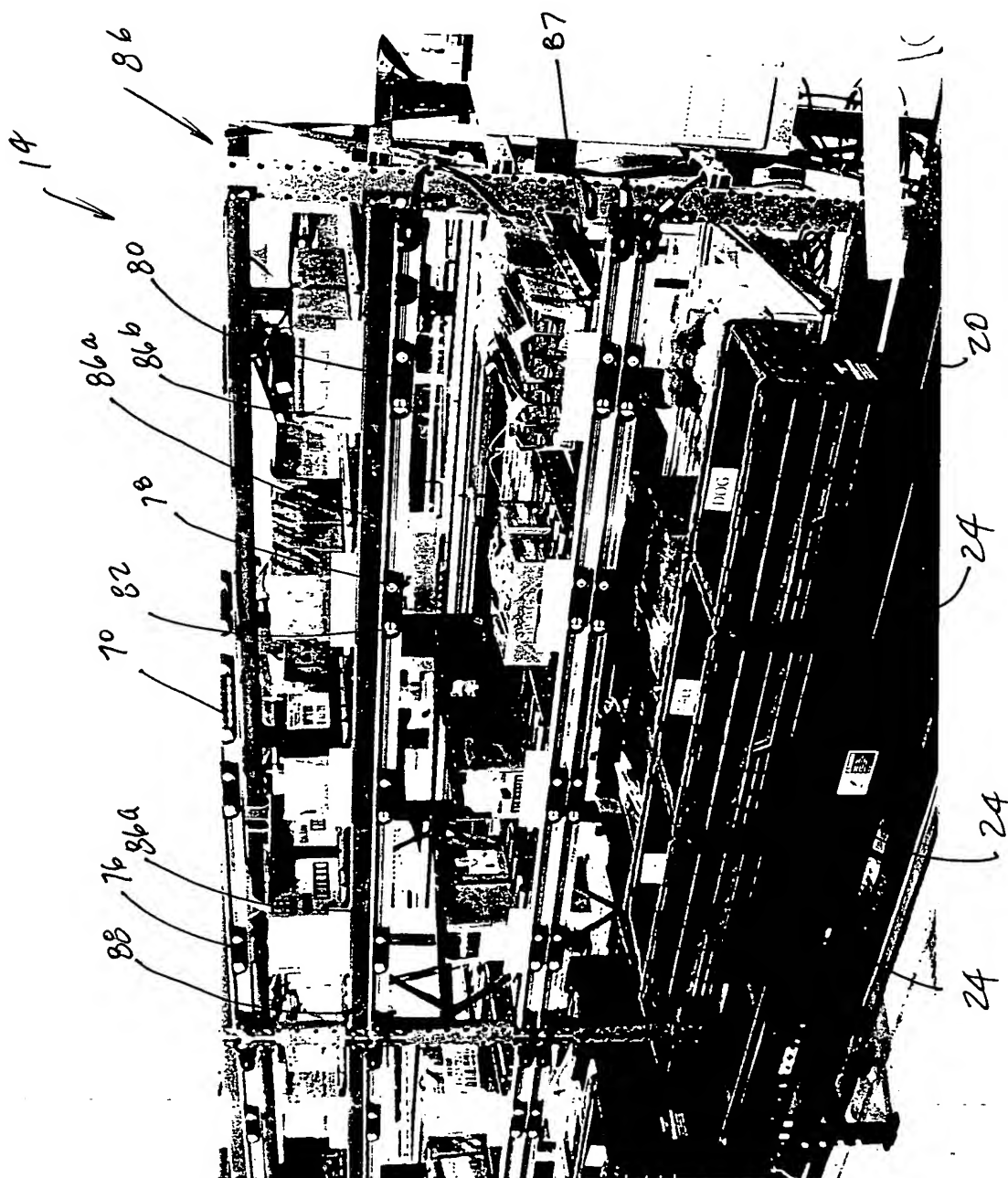


FIG. 8

Sequence One

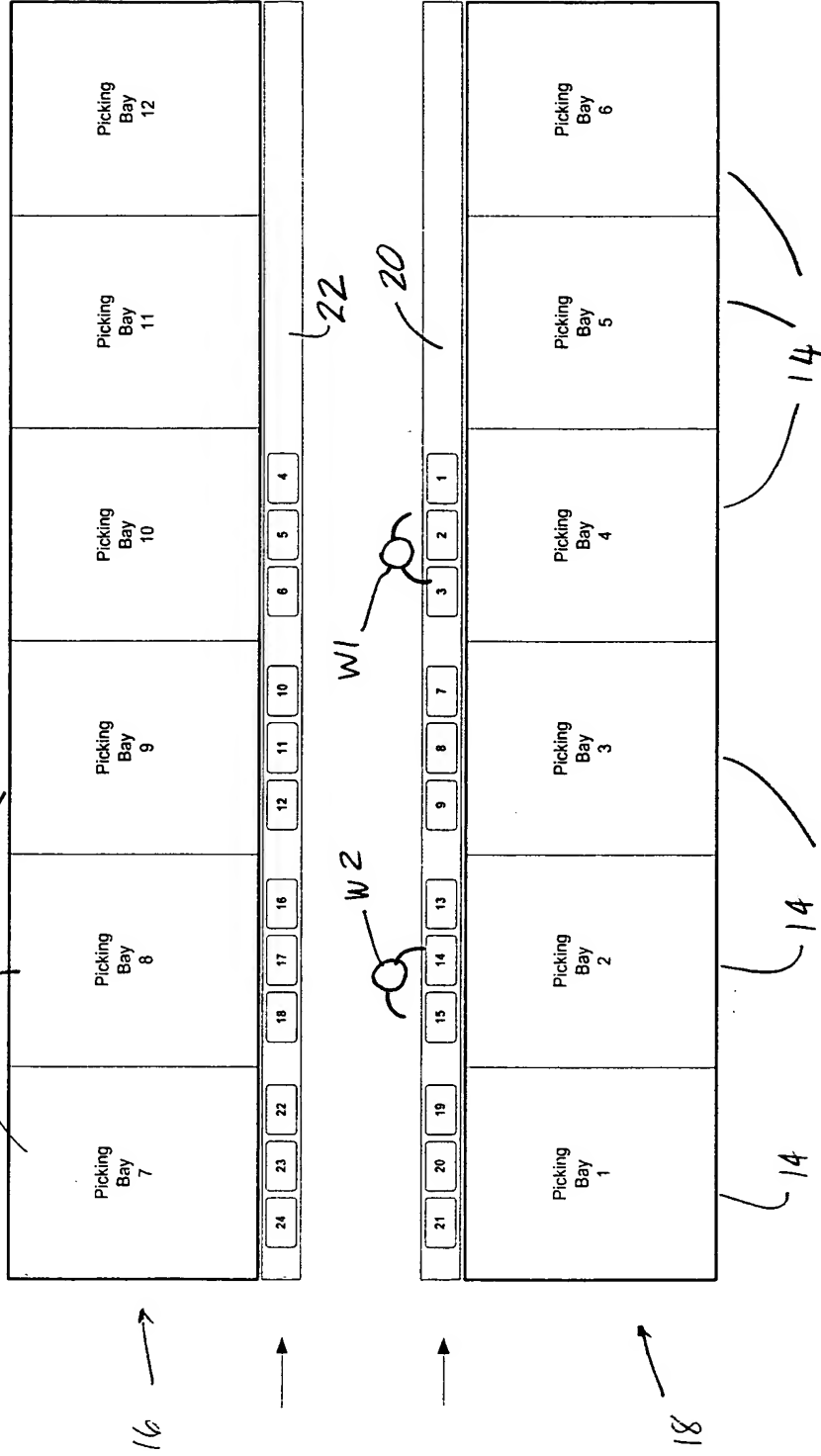


FIG. 9

Sequence Two

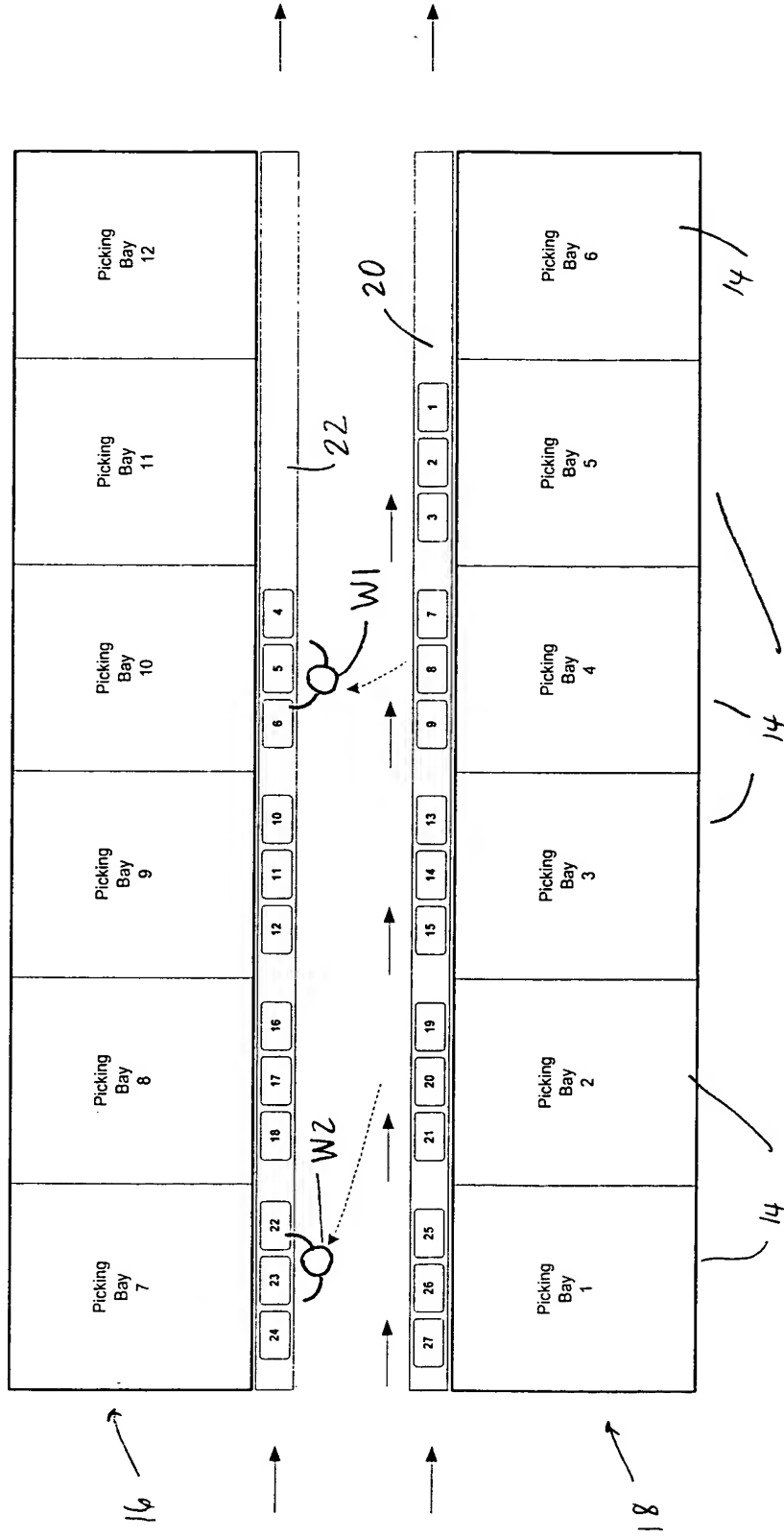


FIG. 10

Sequence Three

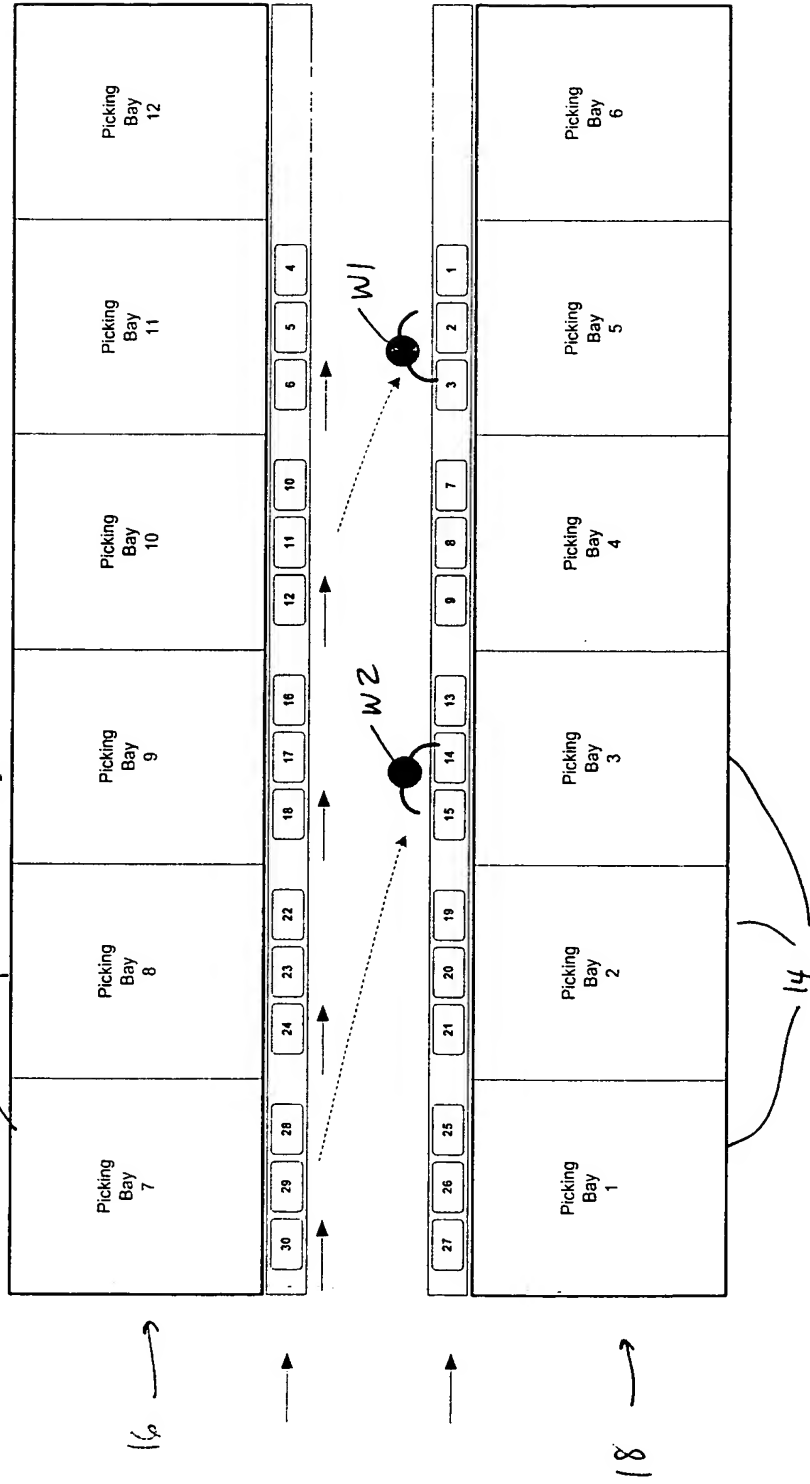


FIG. 11

Sequence Four

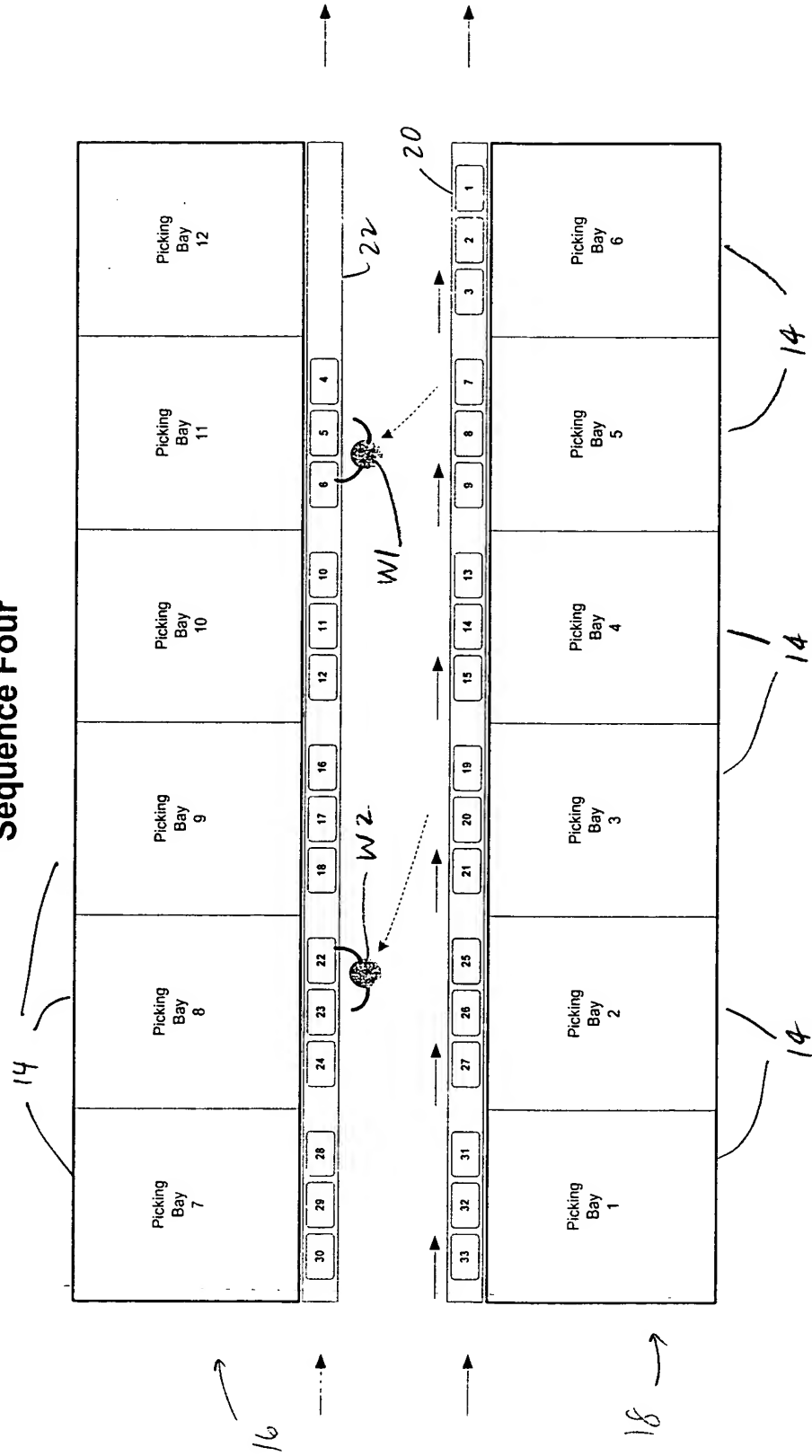


FIG. 12

Sequence Five

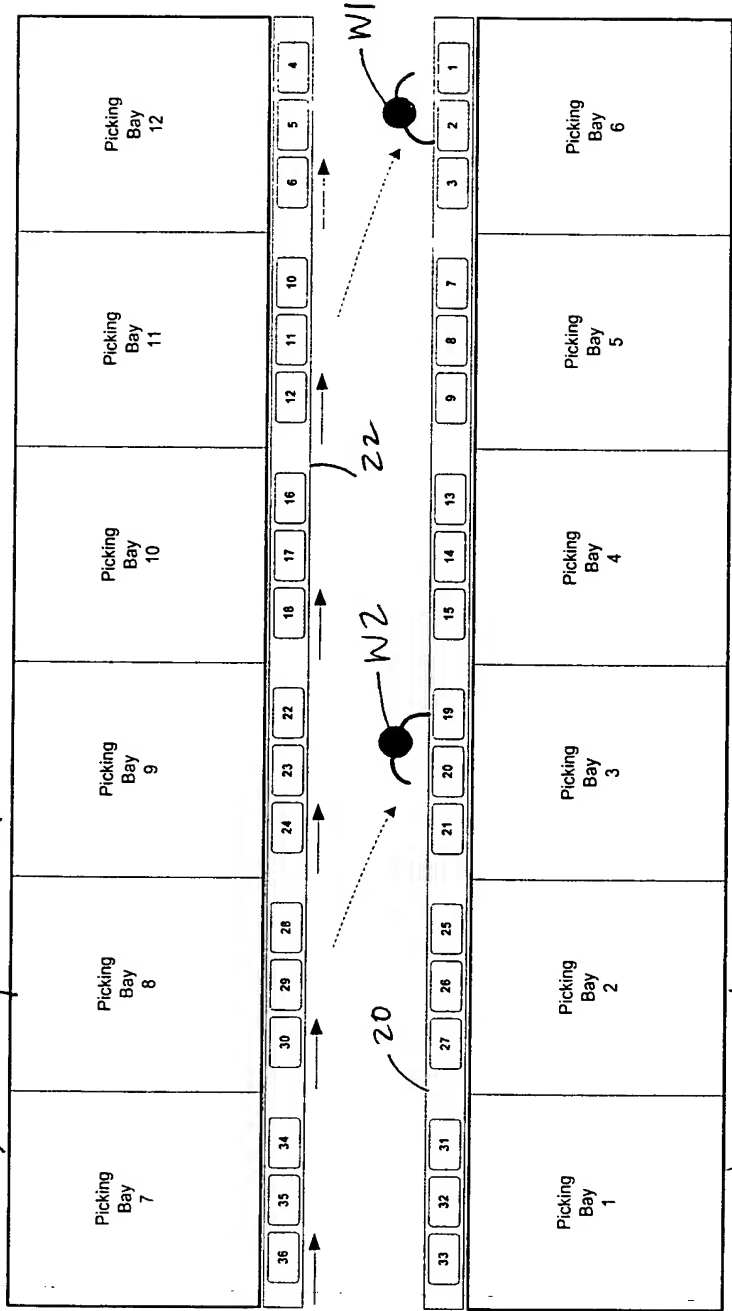


FIG. 13

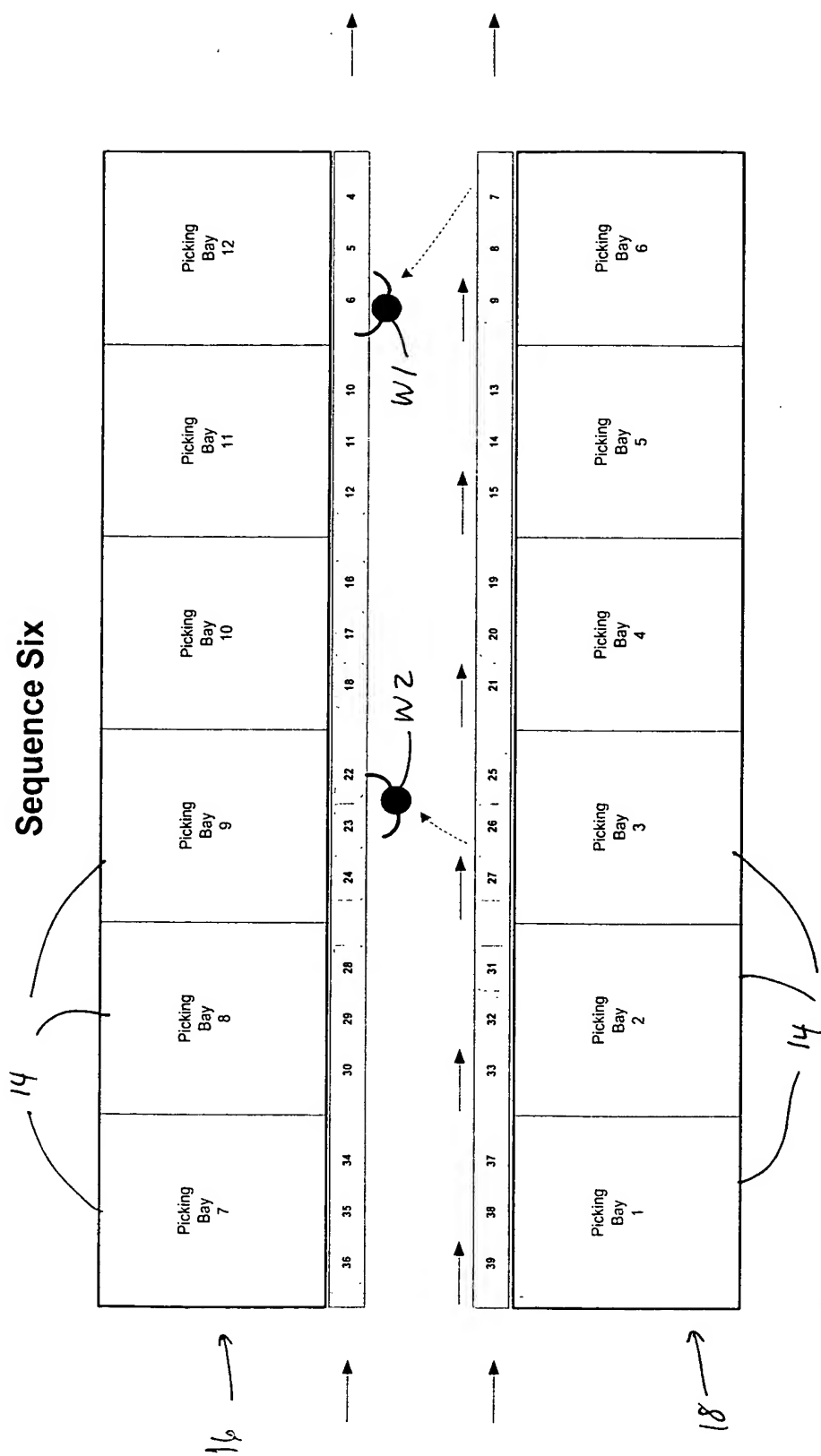


FIG. 14

Sequence Seven

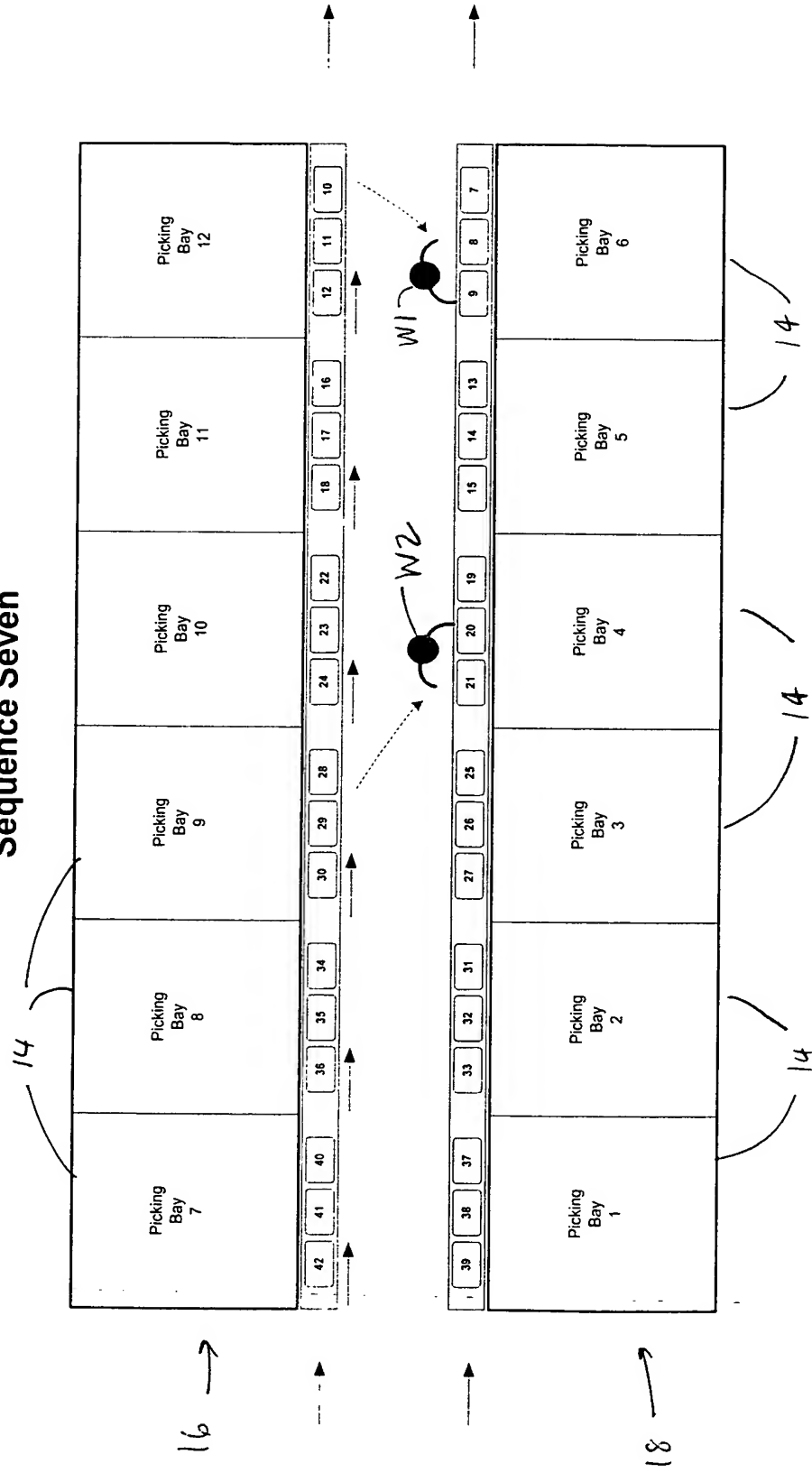


FIG. 15

The diagram illustrates a multi-bay picking system, labeled 14, consisting of two rows of picking bays separated by a central aisle 20. The left row of bays is numbered 7 through 12, and the right row is numbered 1 through 6. Each bay contains a sequence of numbered slots. The left row slots are numbered 42, 41, 40, 36, 35, 34, 30, 29, 28, 24, 23, 22, 18, 17, 16, 12, 11, and 10. The right row slots are numbered 45, 44, 43, 39, 38, 37, 33, 32, 31, 27, 26, 25, 21, 20, 19, 15, 14, and 13. A central aisle 20 runs between the two rows of bays. Two workstations, W1 and W2, are located in the aisle. W1 is positioned between bays 11 and 12 on the left and bays 15 and 16 on the right. W2 is positioned between bays 10 and 11 on the left and bays 25 and 26 on the right. Arrows indicate the flow of material from the bays into the aisle and then towards the workstations. A large arrow 16 points to the left row of bays, and a large arrow 18 points to the right row of bays.

FIG. 16